

Date: Thursday, 6/15/2006 1:41:56 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER  
 Job Number : 27564  
 Estimate Number : 10980  
 P.O. Number : NIA Part Number : D2808  
 This Issue : 6/15/2006 S.O. No. : NIA Drawing Number : D2808 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : A1  
 Previous Run : 26648 Material : NIA  
 Written By : *See 1st comment below* Due Date : 7/5/2006 Qty: *79* Um: Each  
 Checked & Approved By : *OK 06-06-15*  
 Comment : Est Rev:D 02.03.07 Now turned in house NG

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0625 6061-T6 Round Bar .625"



Comment: Qty.: 0.0557 f(s)/Unit Total: 3.3390 f(s)

6061-T6 Round Bar .625"

(M6061T6R0625)

Batch: *M19712*

*65"*

*2711*

*MS 06/06/25*

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit)

2-Deburr

*MS 06/06/25*

*79*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MS 06/06/25*

*79*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*06-06-26*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*06-06-28*

*79*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/06/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 27564

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/06/29 79

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 388

H.M 06-6-30

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/30

Job Completion



u 06-06-30

Powder Coat ~~Black~~  
Gloss white.  
(This Batch only)

9.m 06-06-29

29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

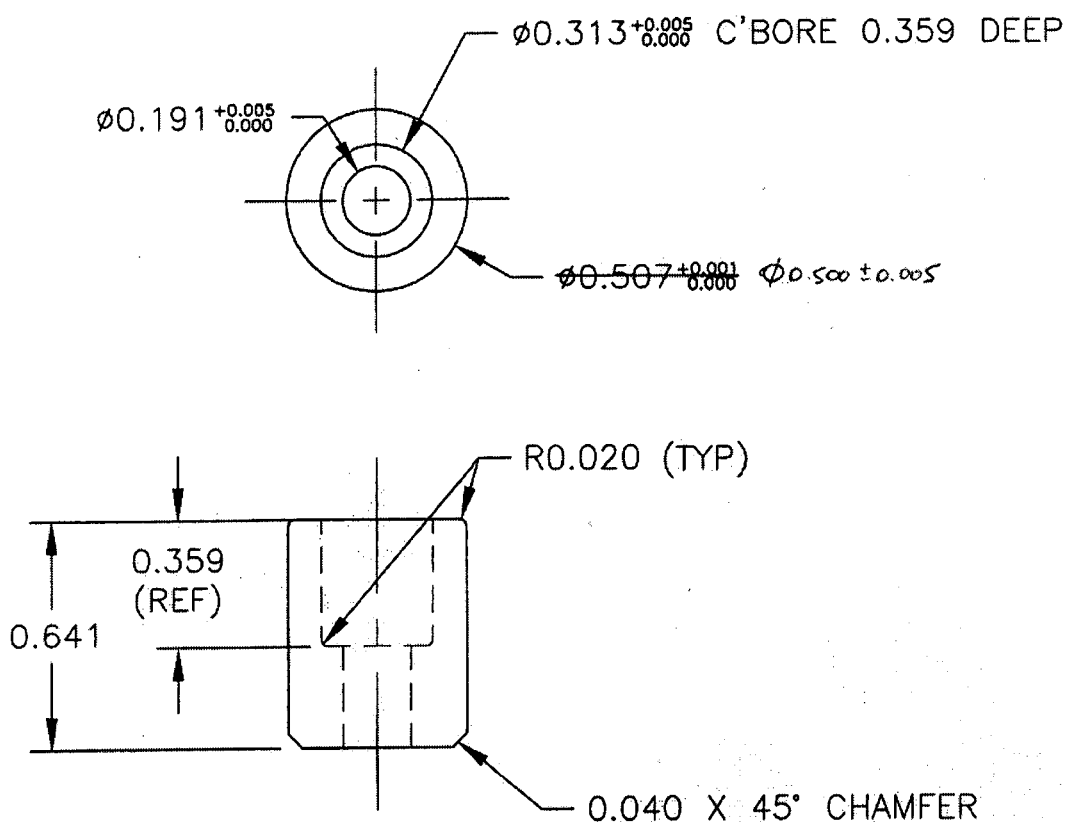
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2808	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	ADD POWDER COAT ; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED  
00.11.13 #



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020  
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.4)  
OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 27564

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